

Date: Tuesday, 8/1/2006 11:23:49 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OH-58 STEP ASSY RH *UNDER REVIEW**
Job Number	: 28050	Part Number	: D058677012
Estimate Number	: 12439	Drawing Number	: D2943 UNDER REVIEW <i>OL FOR THIS w/o 06-08-02</i>
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 8/1/2006 S.O. No. : N/A	Drawing Revision	: UNDER R
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Due Date	: 8/31/2006
Previous Run	: 27399	Qty:	2 Um: Each
Written By	:		
Checked & Approved By	: <i>06.08.02</i>		
Comment	: Est Rev: 01.04.11 Combined with D2943-041 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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(2)

Comment: Photocopy bluefile & type labels per PPPD058-677-012 CHG 01 *KS 06-08-04*

2.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Extrusion D2622-120C

Batch: *327079*

LE. 06-08-16 2

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

D2734 206 Step Endplate

Batch: *327281*

LE. 06-08-16 2

4.0	D2725	206 Step Lug
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

D2725 206 Step Lug

Batch: *320733*

LE. 06-8-16 2

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

2-Deburr and bevel ends for welding

3-Weld end cap(1) and plate as per Dwg D2943 using Jig DT-8482

LE. 06-08-16

LE. 06-08-16

LE. 06-08-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-08-18	5-3 9-0	DT 8483 for R H step weldment. Perm. change.					06-08-18

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/06

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY RH *UNDER REVIEW**

Job Number: 28050

Part Number: D058677012

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R AL ROD

Batch: M100660

4-Grind end cap welds flush as per dwg D2943

PE. 06.08.17

2

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06-08-22

06/08/23 (2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAP 06:08:26 (2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PE. 06.08.30

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last end cap(1) as per Dwg D2943 using Jig DT. ~~8482~~ *8483*

A/R AL ROD

Batch: M15689

PE. 06.08.30

2

2-Grind end cap welds flush as per dwg D2943

PE. 06.08.30

2

10.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06/08/31 (2)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Chemical Conversion Coat as per QSI 005 4.1

A.M. 06-08-31

(2)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

06-08-31 PL 06/09/01 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/1/2006 11:23:49 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 28050

Part Number: D058677012

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

HAND FINISHING1.

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2943 and QSI 005 4.4

Batch: M101662

a.m 06-08-31

(2)

14.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

10/9/06

(2)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

16.0

D27311

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Mounting Lug

Batch: B20613

17.0

D27313

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Mounting Lug

B20614

18.0

D27315

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Mounting Lug

Batch: B23330

19.0

D27317

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Mounting Lug

Batch: B22592

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 26/09/07

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/1/2006 11:23:49 AM
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Job Number: 28050

Part Number: D058677012

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Batch: M100743

21.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch: M101291

22.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Batch: M19085

Rev 9/05 (2)

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/08/05 (2)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Do58-677-012

Location:

PPP Rev: B

Rev 9/05 (2)

25.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/07 (2)

Job Completion



U 06-09-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DESIGN	RF	DRAWN BY	DRAWING NO.	REV. B
CHECKED	<i>[Signature]</i>	APPROVED	D2943	SHEET 1 OF 1
DATE	05.11.14	TITLE	OH-58 STEP ASSEMBLY	SCALE
				NTS

A	99.11.19	NEW ISSUE
B	05.11.14	UPDATE FINISHING NOTE

UNDER REVIEW

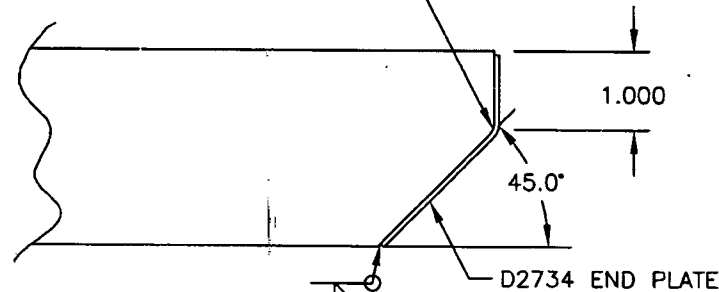
06.03.29 *[Signature]*

RE-DESIGN
SIMILAR TO D296-638

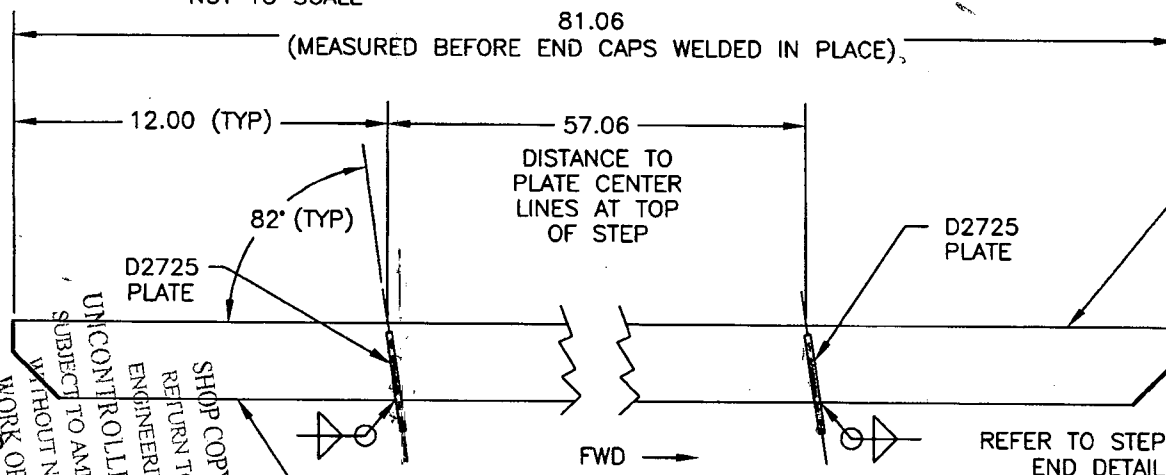
RELEASED
05.11.28 *[Signature]*
OK FOR THIS W/O
06.08.02

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

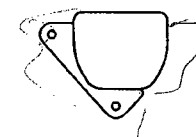
ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE



APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



D2943-1 MAKE FROM EXTRUSION D2622
D2943-041 LH STEP ASSEMBLY (SHOWN)
D2943-042 RH STEP ASSEMBLY (OPPOSITE)

D2943-041/-042 OH-58 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2943-041	LH STEP ASSEMBLY
	X	D2943-042	RH STEP ASSEMBLY
1	1	D2622-082*	EXTRUSION
2	2	D2725	PLATE
2	2	D2734	END PLATE

*cut per drawing

D2943-041/-042 OH-58 STEP ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

